



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

DSK078
Job Sheet 171103



Part No: DSK078

Job Qty: 6 ea

Part Name: D2893-1 Turning Detail



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/29/18

Job Tracking No:

Due Date: 1/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP rev A. 08.03.13 new issue EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	1/30/18	1/30/18	0.00	0.00	Start Up Machining-4		
100	Doosan	6 pcs	1/31/18	1/31/18	0.50	5.26	Doosan		
110	QC	6 pcs	1/31/18	1/31/18	0.00	0.00	QC2 Machining-4		
120	QC	6 pcs	1/31/18	1/31/18	0.00	0.00	QC8 Machining-4		
130	Packaging	6 pcs	1/31/18	1/31/18	0.00	0.00	Packaging3-2		
140	QC21-SA	6 Ea	1/31/18	1/31/18	0.00	0.00	QC21		

Part Op 100 - Turn blank as per Folio FA081 (4TH AXIS PLUG DT8492)
Descriptions: 130 - LOCATION: MAT060

ML5 FEB 01 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6104-005	Round Billet, 17-4	6 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6104-005	6	12	0

Part Specifications

Specifications could not be found.

Plex 1/29/18 5:43 AM Dart.lajeunesse.marie

DQA:

Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only ☐

Work Order: _____

DISPOSITION

AGAINST DEPARTMENT / PROCESS

Part No. _____

Rework ☐

Skid-1

Scrap ☐

Machi

Use-as-is ☐

Thermoform

NCR No. _____

Suspected Unapproved ☐

Large

Date : _____

Step #: _____

QTY E

Description Work Order Deviation**Dart Aerospace Ltd.**

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

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Approval

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ising
Start up Operation 02/01/18**Job No: 171103****Root Cause**Environment ☐No Re-verification ☐Design ☐Operator ☐Doc/Data ☐Offset/Setup ☐Equip/Tooling ☐Supplier ☐Handling/Pre ☐Training ☐Material ☐Use for Testing ☐Internal Transport ☐Poor Information ☐Tribal Knowledge ☐Rushing ☐LOA ☐Product Improvement ☐Substation ☐Process Improvement ☐Past Expiry Date ☐Manufacturing Process ☐Misidentified ☐Past Due ☐Pressure/Forced ☐Temperature/Cu ☐Bending ☐Set-up ☐Centre Not Concentric ☐BOM/Route ☐Cracks ☐Broken/Damage/ ☐Crimp/Kink/Ripple/Wave ☐Inspection Incom ☐Cuffs ☐Contamination ☐Crushing ☐Countersink ☐Heat Treat ☐Cut Too Short ☐Wave/Twist in Tube ☐Instructions Incon ☐Marks/Chatter ☐Drill Holes ☐

OTHER : _____

DART
AEROSPACE
S037938
**D2893 - 1 Turning Detail**
PART NO: DSK078
Original Serial #: S037938
Revision:
Operation:
Change No:
Misaligned/off center ☐Turning Sequence ☐

DART AEROSPACE LTD		Work Order:	171103
Description: Turning Detail for D2893-1		Part Number:	DSK078
Inspection Dwg: DSK078		Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.707	2.712		2.709	2.707	2.707	2.707	2.708
B	4.946	4.966		4.955	4.950	4.956	4.955	4.956
C	3.064	3.084		3.073	3.073	3.072	3.073	3.073
D	0.718	0.738		0.728	0.728	0.728	0.728	0.728
E	0.090	0.110		0.100	0.100	0.100	0.100	0.100
F	2.934	2.954		2.942	2.940	2.941	2.940	2.940
G	2.166	2.186		2.176	2.176	2.176	2.176	2.176
H	3.890	3.910		3.899	3.898	3.898	3.899	3.898
I	0.914	0.934		0.924	0.924	0.924	0.924	0.924
J	0.022	0.042		0.032	0.032	0.032	0.032	0.032
K	0.109	0.129		.117	.117	.118	.118	.117
L								
M								
N								
O								
P								

Measured by:		Date:	18-02-01
Audited by:	A.e	Date:	18-02-01
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approval
A	08.04.22	New Issue	KJ/JLM	

DART AEROSPACE LTD		Work Order: 171103
Description: Turning Detail for D2893-1		Part Number: DSK078
Inspection Dwg: DSK078	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	#6	#7	#8	9#1	#10
Lathe Section								
A	2.707	2.712		2.707	2.707	2.705	2.708	2.709
B	4.946	4.966		4.955	4.957	4.955	4.956	4.956
C	3.064	3.084		3.072	3.072	3.073	3.073	3.072
D	0.718	0.738		.724	.724	.724	.724	.724
E	0.090	0.110		.100	.100	.100	.100	.100
F	2.934	2.954		2.940	2.941	2.940	2.942	2.940
G	2.166	2.186		2.176	2.176	2.176	2.176	2.176
H	3.890	3.910		3.899	3.899	3.898	3.899	3.898
I	0.914	0.934		.924	.924	.924	.924	.924
J	0.022	0.042		.032	.032	.032	.032	.032
K	0.109	0.129		.118	.118	.118	.117	.118
L								
M								
N								
O								
P								

Measured by:  Date: 18-02-01

Audited by:  Date: 18-02-01

Prototype Approval: _____ Date: _____

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM 	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

DART AEROSPACE LTD		Work Order: DSK078
Description: Turning Detail for D2893-1		Part Number: DSK078
Inspection Dwg: DSK078	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1#	2#	3#	4#	5#
Lathe Section								
A	2.707	2.712		2.707	2.707			
B	4.946	4.966		4.956	4.957			
C	3.064	3.084		3.072	3.074			
D	0.718	0.738		.724	.724			
E	0.090	0.110		.100	.100			
F	2.934	2.954		2.940	2.940			
G	2.166	2.186		2.176	2.176			
H	3.890	3.910		3.899	3.899			
I	0.914	0.934		.924	.924			
J	0.022	0.042		.032	.032			
K	0.109	0.129		.117	.117			
L								
M								
N								
O								
P								

Measured by: [Signature]	Date: 16-02-01
Audited by: A.A	Date: 18-02-01
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	[Signature]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

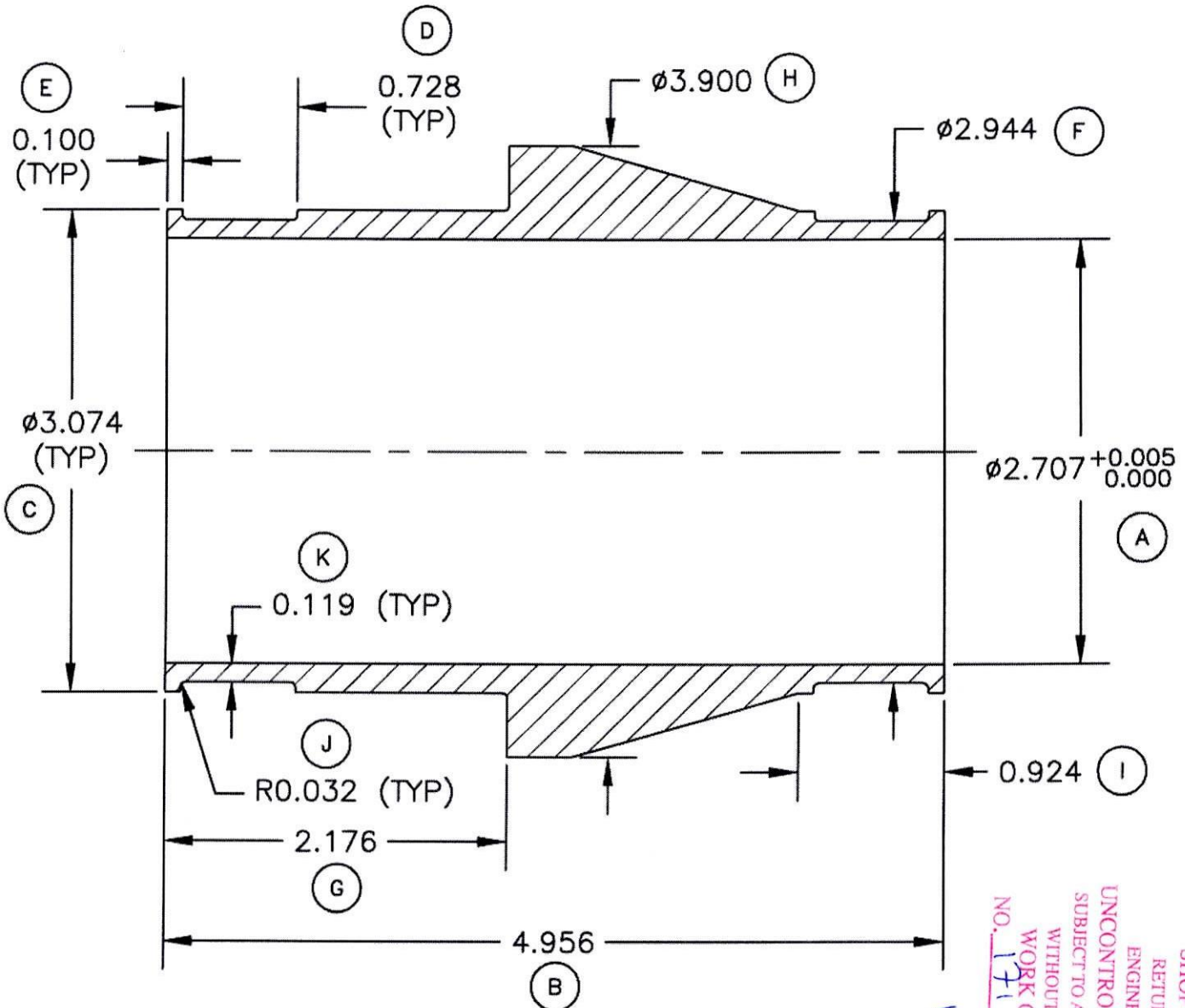
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								



DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. DSK 078	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2893-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED
03.07.01



D2893-1 TURNING DETAIL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 171103 MJS
18-01-29

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					